

CECW-ET Engineer Manual 1110-2-2704	Department of the Army U.S. Army Corps of Engineers Washington, DC 20314-1000	EM 1110-2-2704 1 January 1999
	Engineering and Design CATHODIC PROTECTION SYSTEMS FOR CIVIL WORKS STRUCTURES	
	Distribution Restriction Statement Approved for public release; distribution is unlimited.	

DISTRIBUTION STATEMENT A
Approved for Public Release
Distribution Unlimited

CECW-ET

DEPARTMENT OF THE ARMY
U.S. Army Corps of Engineers
Washington, DC 20314-1000

EM 1110-2-2704


Manual
No. 1110-2-2704

1 January 1999

Engineering and Design
CATHODIC PROTECTION SYSTEMS FOR CIVIL WORKS STRUCTURES

- 1. Purpose.** This manual provides guidance for the selection, design, installation, operation, and maintenance of cathodic protection systems (CPS's) for navigation lock gates and other civil works hydraulic structures.
- 2. Applicability.** This manual applies to all USACE Commands having civil works responsibilities.
- 3. Discussion.** The primary corrosion control method for civil works hydraulic structures is a protective coating system, most often paint. Where the paint system and structure are submerged in water, a combination of the anodic and cathodic properties of materials, the liquid electrolyte, and external electrical circuits combine to form electrochemical corrosion cells, and corrosion naturally follows. CPS's can supplement the paint coating system to mitigate corrosion damage.
- 4. Distribution.** Approved for public release; distribution is unlimited.

FOR THE COMMANDER:



ALBERT J. GENETTI, JR.
Major General, USA
Chief of Staff

CECW-ET

DEPARTMENT OF THE ARMY
U.S. Army Corps of Engineers
Washington, DC 20314-1000

EM 1110-2-2704

Manual
No. 1110-2-2704

1 January 1999

Engineering and Design
CATHODIC PROTECTION SYSTEMS FOR CIVIL WORKS STRUCTURES

Table of Contents

Subject	Paragraph	Page	Subject	Paragraph	Page
Chapter 1			Chapter 6		
Introduction			System Design, Construction,		
Purpose and Scope	1-1	1-1	Operation, Maintenance, and		
Applicability	1-2	1-1	Restoration		
References	1-3	1-1	Design	6-1	6-1
Background	1-4	1-1	Construction	6-2	6-1
			Operation and Maintenance	6-3	6-2
			Restoration	6-4	6-2
Chapter 2			Chapter 7		
Corrosion Mitigation Plan			Training and Services		
Corrosion Protection Coordinator ..	2-1	2-1	Training	7-1	7-1
Plan	2-2	2-1	Services	7-2	7-1
Tests and Adjustments	2-3	2-1			
Chapter 3			Appendix A		
Expert Assistance			Sample Corrosion Mitigation		
Background	3-1	3-1	Plan		
Expertise	3-2	3-1			
Assistance	3-3	3-1	Appendix B		
Element Responsibility	3-4	3-1	Detailed Cathodic Protection		
Chapter 4			Design Procedures for Pike		
Testing and Optimizing			Island Auxiliary Lock Gates		
Equipment and Personnel	4-1	4-1			
Optimizing System	4-2	4-1			
Chapter 5					
System Selection					
Corrosion Protection	5-1	5-1			
Types of CPS's	5-2	5-1			
CPS Selection	5-3	5-1			

20020628 033

Chapter 1 Introduction

1-1. Purpose and Scope

This manual provides guidance for the selection, design, installation, operation, and maintenance of cathodic protection systems (CPS's) used to supplement paint systems for corrosion control on civil works hydraulic structures. It also discusses possible solutions to some of the problems with CPS's that may be encountered at existing projects.

1-2. Applicability

This manual applies to all USACE Commands having civil works responsibilities.

1-3. References

- a. MIL-HDBK-1004/10, Electrical Engineering Cathodic Protection.
- b. EM 1110-2-3400, Painting: New Construction and Maintenance.
- c. ETL 1110-9-10, Cathodic Protection Systems Using Ceramic Anodes.
- d. CW-09940, Painting; Hydraulic Structures and Appurtenant Works.
- e. CW-16643, Cathodic Protection Systems (Impressed Current) for Lock Miter Gates.
- f. TN ZMR-3-05, Components of Hydropower Projects Sensitive to Zebra Mussel Infestations.
- g. NACE International Standard RP0169-96, Recommended Practice, Control of External Corrosion on Underground or Submerged Metallic Piping Systems.

1-4. Background

a. *General.* The Corps uses CPS's in combination with protective coatings to mitigate corrosion of hydraulic structures immersed in fresh,

brackish, or salt water. Protective coatings are rarely completely effective because, even on application, they contain pinholes, scratches, and connected porosity. As coatings degrade with time, these imperfections, commonly known as holidays, have a profound effect on overall coating integrity because of underfilm corrosion. CPS's, when used in conjunction with protective coatings, have been effective in controlling corrosion. CPS's consist of anodes that pass a protective current to the structure through the electrolyte environment. CPS's can be one of two types, sacrificial anode or impressed current anode. Hybrid CPS's installed on structures can contain both types of anodes to provide protective current.

(1) Sacrificial anodes, such as magnesium or zinc alloy, corrode and wear more readily than the structure to be protected because of their more negative electrochemical potential. Sacrificial anodes do not require an outside power source; rather, they provide their own power and need very little maintenance. They should be replaced whenever the anode material has been consumed, so they should be easily accessed. Sacrificial anodes are generally recommended for use with a well-coated structure with minimum chance of being damaged during its useful life.

(2) Impressed current anodes are made of durable materials that resist electrochemical wear or dissolution. The impressed current is supplied by a power source such as a rectifier. All impressed current CPS's require routine maintenance because they involve a power supply and a greater number of electrical connections than do sacrificial anodes. However, impressed CPS's can be used with bare or poorly coated structures because of the greater current capacity.

b. *Locations.* Since 1950, USACE has used impressed current CPS's with graphite or high-silicon, chromium-bearing cast iron (HSCBCI) anodes. The first systems were installed on the Mississippi River near Rock Island, IL, on an experimental basis. Since then, CPS's have been used widely. About 22 CPS's were installed and are currently functioning on structures on the Tennessee-Tombigbee Waterway, the Alabama River, and the Black Warrior River in the Mobile District. CPS's have been used successfully on the Intercoastal Waterway on seven sector gates in

the Jacksonville District and on miter gates in the New Orleans District. Impressed current systems have also been installed on three lock gates on the Columbia River in the Northwest. Similarly, impressed current systems using both graphite and HSCBCI anodes were installed on lock gates on the Ohio River during the 1970's. However, ice and debris damages have made most of these systems inoperable. Since the early 1980's, a new type of ceramic-coated composite anode material has been used for various electrochemical processes, particularly in the electrolytic production of chlorine and cathodic protection systems, including off-shore, water tank, and groundbed applications. The mixed metal oxide ceramic-coated anodes consist of a conductive coating of iridium or ruthenium oxide (IrO_2 and RuO_2 , respectively) applied by thermal decomposition onto specially prepared titanium substrates. The coatings are applied by spraying aqueous metallic salts onto the titanium substrates and heating to several hundred degrees Celsius. Multiple layers of coating material may be applied by the process to provide a maximum coating thickness of approximately 0.025 mm (1 mil). This type of CPS has been used at Pike Island and other locations with good results.

c. Inoperable impressed current systems. Most of the inoperable impressed current systems encountered were utilizing graphite anodes that were more than 20 years old. Only a few navigation structures have had systems that utilized sausage string cast iron anodes provided with impact protection. Properly maintained cast iron anode systems that have been in high-impact debris areas have shown good results. Graphite systems in low-impact debris areas have also shown good results.

d. Inoperable sacrificial anode systems. Zinc or magnesium sacrificial anodes provide some benefits, but typically, these anodes only protect small areas such as well-coated structures, and they experience higher consumption rates than anodes normally used in an impressed current system. In order to be

beneficial, sacrificial anodes must continue to apply current to the structure. Consequently there must be periodic voltage testing, and the system must be kept optimized by anode replacement to continue its performance in accordance with acceptable criteria.

e. Solutions.

(1) Restoration of systems. Most existing inoperable CPS's at navigation structures can be restored. This approach is less expensive than installing complete new systems, and therefore should be considered first. When graphite anode strings are consumed or destroyed, they can be replaced with impact-protected cast iron anode strings or ceramic-coated wire. In many cases, anode strings can be replaced and systems can be repaired without dewatering a lock.

(2) New or replacement systems. Designers should use Guide Specification CW-16643 with this manual for new CPS installation or for complete system replacement when necessary.

f. Effective techniques. National Association of Corrosion Engineers (NACE) Standard RP0169-96 contains the recommended practice for control of external corrosion on civil works hydraulic structures. It includes criteria for both coatings and cathodic protection and should be used in conjunction with guidance in this manual and with painting design guidance in Engineer Manual EM 1110-2-3400. NACE Standard RP0169-96 should also be used as guidance unless noted otherwise, and designers should become familiar with it.

g. Resistivity policy. Cathodic protection should be provided on all submerged metallic structures. If, after performing a corrosion mitigation survey, an NACE-certified corrosion specialist or a professional engineer deems cathodic protection unnecessary due to a noncorrosive water, a statement to that effect should be prepared and sent to the district project manager as a part of the corrosion plan.

Chapter 2

Corrosion Mitigation Plan

2-1. Corrosion Protection Coordinator

Each district should designate a person who has experience and is familiar with cathodic protection techniques to serve as the district corrosion protection coordinator. Such a person may be a licensed professional engineer or a person certified as being qualified by NACE International as a cathodic protection specialist, corrosion specialist, or senior corrosion technologist. This individual will be responsible for ensuring that the CPS's are tested and optimized and that reports of the results are prepared and maintained at the district for review of system effectiveness.

2-2. Plan

a. Development. A corrosion mitigation plan should be developed by the district corrosion protection coordinator for each hydraulic structure.

(1) New projects. A corrosion mitigation plan should be developed and included in the design memorandum. For an already completed design memorandum, the plan should be developed and submitted as a supplement to the design memorandum prior to completion of plans and specifications.

(2) Existing projects. A corrosion mitigation plan should be developed and presented as an appendix in a Periodic Inspection Report for reference in subsequent inspections. Corrosion mitigation plans should consider the condition of existing structures, factors that affect the rate of corrosion, methods of corrosion control, and cathodic protection of the structure.

b. Execution. The following policy on optimization, testing, and reporting of the CPS for each structure should be followed.

(1) A survey of the structure-to-electrolyte potential, using a standardized reference cell, should be performed. Any system failing to operate in accordance with established criteria should be optimized by adjustment.

(2) A report showing the condition of the CPS's and including any plans to repair the systems should be prepared and kept at the district for review.

(3) Any inoperable CPS should be repaired as needed.

2-3. Tests and Adjustments

a. Tests, adjustments, and data collection. Tests should be performed in accordance with the corrosion mitigation plan. Rectifier voltages and currents should be recorded. There are no prescribed time intervals for testing new systems, but measurements should be taken and recorded monthly until steady-state conditions are reached. Then, based upon the judgment of the corrosion protection coordinator, tests should be performed at about 6-month intervals for a year or more, and thereafter at yearly intervals. It would be appropriate to monitor critical or strategic structures more frequently. Based upon the measurements taken, the rectifier current and voltage should be adjusted to produce either a negative polarized (cathodic) potential of at least 850 mV with the cathodic protection applied or other minimum cathodic polarization such as 100-mV polarization as described in NACE RP0169-96 for steel and cast iron piping. This potential should be achieved over 90 percent of each face of each gate leaf. Readings should not exceed a polarized (cathodic) potential of 1200 mV at any location. Acceptance criteria for CPS's should be as defined in NACE Standard RP0169-96 unless otherwise noted in this manual.

b. Reports. Reports should be prepared and kept at the district. These reports should be presented in a format similar to that in the Appendix A sample and table for a miter gate, showing measurements taken and data obtained. For other types of installations, the report should be modified to show similar data applicable to the respective installation. This report should be completed yearly not later than December.

c. Data. The data accumulated in these reports should be retained to provide a database for consideration of possible improvements to CPS techniques. The current corrosion deterioration status of the structures should be maintained.

Chapter 3

Expert Assistance

3-1. Background

Some Corps districts and laboratories have long been involved in planning, designing, procuring, installing, testing, operating, and maintaining various types of CPS's for navigation structures. Expertise is available to assist USACE elements in any of the above areas on a cost reimbursable basis. For further information concerning USACE expert assistance in the above-mentioned areas, please contact CECW-ET, HQUSACE.

3-2. Expertise

District personnel who have limited experience and expertise in CPS's are encouraged to seek assistance from other districts and/or laboratories through their Corrosion Protection Coordinator.

3-3. Assistance

The specific areas of assistance include initial planning, preparation and/or review of design and solicitation packages, review of design submittals, review of shop drawings or contract changes, training, and preparation of corrosion mitigation test plans. Assistance is also available, in troubleshooting, restoring, testing, and adjusting and optimizing CPS's.

3-4. Element Responsibility

USACE elements will be responsible for ensuring that all solicitations comply with current procurement policy, including consideration of the offeror's experience and qualifications. Although the procurement method selected for any given project is at the discretion of the responsible element, the intent of this manual is to provide guidance so that all contractors in cathodic protection have qualifications which, as a minimum, meet the requirements in Chapter 6.

Chapter 4

Testing and Optimizing

4-1. Equipment and Personnel

Test equipment should consist of a fresh and calibrated copper-copper-sulfate reference cell, a submersible connection, cabling suitable for immersion use, and a high-impedance voltmeter capable of measuring polarized potentials with the CPS on. Sensitivity should be more than 5 meg-ohms per volt. The reference electrode should be placed in the electrolyte adjacent within 200 mm to the face of the gate at each test point. All tests should be supervised by an NACE-certified corrosion specialist, senior corrosion technologist, or cathodic protection specialist, a licensed corrosion engineer, or a Corps of Engineers representative assigned and qualified to do this work.

4-2. Optimizing System

Data collected during the test should be reviewed, and any necessary adjustments should be made. The system should be properly optimized by adjusting the rectifier until 90 percent of the potentials fall within the range of polarized (cathodic) potential of between negative 850 mV and negative 1200 mV or 100-mV polarization according to NACE RP0169-96. A report on test results should be prepared and retained at the district. Research and development work on low-cost remote monitoring systems has been performed recently to increase reliability, extend service life, minimize maintenance requirements, and automate the CPS testing, evaluation, and diagnostic procedures to reduce the life-cycle cost of CPS's. For further information concerning the remote monitoring system, please contact CECW-ET, HQUSACE.

Chapter 5

System Selection

5-1. Corrosion Protection

Corrosion occurs on all metallic structures that are not adequately protected. The cost of replacing a structure which may have been destroyed or weakened due to excessive corrosion is substantial but avoidable, and means should be taken to prevent or mitigate this added cost through cathodic protection. In addition to preparing and applying protective coatings to the surface of a structure, a technique used to further prevent corrosion is to apply a protective current to the structure surface which contacts an electrolyte. This technique prevents or reduces the rate of surface corrosion by making the surface cathodic in the presence of other metals contacting the electrolyte.

5-2. Types of CPS's

a. Sacrificial CPS. This system helps reduce surface corrosion of a metallic structure immersed in an electrolyte by metallicity coupling a less noble, i.e., more negative, metal with the structure. This system is based on sacrificing the more negative anodic metal to save the structure from deterioration by corrosion. Usually the anodic metals used are composed of zinc or magnesium.

b. Impressed current CPS. This system uses direct current applied to an anode system from an external power source to drive the structure surface to a state that is cathodic with respect to other metals in the electrolyte. Two types of anodes can be used; string anodes are installed either adjacent to or on the structure, and button anodes are installed on the structure. Both types must be isolated from the surface of the structure. Civil works systems are usually impressed current systems.

5-3. CPS Selection

When selecting which type of system to use, the designer should consider the size of the structure to be protected and past project experience in operating and

maintaining both types of systems. Sacrificial anode systems on large structures such as gates deteriorate rapidly and become ineffective. However, a properly maintained impressed current system can last 10 to 30 years on the same structure.

a. Basis for selecting an impressed current system.

- (1) Can be designed for a wider range of voltage and current applications.
- (2) Higher ampere-years can be obtained from each installation.
- (3) One installation can protect a more extensive area of the surface of the metallic structure.
- (4) Voltage and current can be varied to meet changing conditions. This provides an operational flexibility that is very desirable to increase protection of the surface coating.
- (5) Current requirement can be read and monitored easily at the rectifier.

- (6) System can be used for protecting bare or poorly coated surfaces of metallic structures.

b. Basis for selecting a sacrificial anode system.

- (1) External power source is not required.
- (2) Installation is less complex since an external power source, including rectifier, is not required.
- (3) This system works very well when resistivity is low, the structure is well coated, easy access to the structure is available, and significant deterioration of coating (paint) is not expected within 5 to 10 years.
- (4) This system is easier to install on moving complex structures such as tainter valves where routing of cables from an impressed current system could present a problem.

c. Basis for not selecting a sacrificial anode system.

(1) Current output is limited. It has limited driving potential, therefore the protection for the bare steel area from each anode is limited.

(2) Sacrificial anode systems generally cannot be justified in water media when large surface areas of a poorly coated metallic structure require protection.

(3) Installation can be expensive. A greater amount of anode material is required due to the much higher anode consumption rates.

(4) Past experience has shown that as the protective coating deteriorates (or when surface areas of the metallic structure are physically scarred or scraped) more current and variations in current are required. The sacrificial anode system cannot respond to the additional bare area since its current and voltage are limited and cannot be varied.

(5) Due to the buildup of algae, silt, or other deposits on sacrificial anodes, the current output of the anode may be reduced.

(6) Basis of design must consider future and changing conditions of structure surface which is not considered in the design of sacrificial anode and impressed current systems.

(7) Although the sacrificial anode systems require less maintenance than impressed current systems, they nevertheless require some maintenance. Since there is no method to monitor a sacrificial anode system to determine if it is operating in accordance with NACE criteria, except by taking structure-to-electrolyte potential measurements, many times this type of system is neglected, resulting in damage to the structure.

Chapter 6

System Design, Construction, Operation, Maintenance, and Restoration

6-1. Design

For existing structures, a current requirement test should be made to accurately assess the overall system design. The designer should become familiar with the availability and suitability of types of commercially manufactured anodes which would satisfy the system requirements for cathodic protection. Chapter 5 provides guidance for selecting impressed current and sacrificial anode systems. The designer should become familiar with manufacturer recommendations for use and product performance claims. CPS's should be designed to attain and maintain a level of protection of the structure as defined in the section "Criteria and Other Considerations for Cathodic Protection" in NACE RP0169-96. In order to achieve this level of protection, design calculations must be made to determine the number and types of anodes required. Examples of calculations can be found in Appendix B of this manual for impressed current cathodic protection design, in ETL 1110-9-10 for cathodic protection systems using ceramic anodes, and in MIL-HDBK-1004/10, "Electrical Engineering Cathodic Protection," a handbook developed from evaluations, surveys, and design practices of the Naval Facilities Engineering Command, other Government agencies, and the private sector. MIL-HDBK-1004/10 can be a useful tool for design calculations in conjunction with the criteria that follow. These calculations must take into consideration the total area of the structure to be protected, the resistivity of the electrolyte, the present condition of the protective coatings on the structure, the predicted deterioration of these coatings due to physical damage, the normal paint change of state over a 20-year period, and the environment to which the structure will be subjected. The design of CPS's should be accomplished under the supervision of a certified NACE corrosion specialist, a cathodic protection specialist, or a professional engineer licensed in corrosion engineering.

a. Criteria. NACE International criteria for protection for steel and cast iron piping, covered under paragraph 6.2.2 and subparagraphs of NACE

International RP0169-96, should be met for design of civil works hydraulic structures. Those criteria are specifically included here by reference.

b. Guide specification. Guide Specification CW-16643, "Cathodic Protection Systems (Impressed Current) for Lock Miter Gates," should be used in preparing contract documents for procurement of CPS's. This specification, in addition to providing the technical requirements for various items of equipment for the CPS, addresses methods for protection from ice and various debris of the string anodes and the electrical leads to the button and string anodes. This specification is based upon the use of impressed current systems, which are normally used on hydraulic structures having large areas requiring corrosion protection. Button-type anodes are normally used on the skin plate side of the gate with string-type anodes installed in the compartment areas of the gate; however, button-type anodes may also be used in the compartment areas.

c. Zebra mussel guidance. In areas with potential for zebra mussel infestations, the CPS components may be at risk of failure or disruption. Design considerations in preventing these infestations should be included. For control strategies, refer to Zebra Mussel Research Technical Note ZMR-3-05, compiled by the Zebra Mussel Research Program at Waterways Experiment Station, Vicksburg, MS.

6-2. Construction

Installation of a CPS by a construction contractor should be accomplished under the supervision of an NACE International corrosion specialist, senior corrosion technologist, or cathodic protection specialist or a licensed corrosion engineer.

a. Services of corrosion engineer. The construction contractor should be required to obtain the services of a licensed corrosion engineer to supervise the installation and testing of the CPS. The term "corrosion engineer" refers to a person who has knowledge of the physical sciences and the principles of engineering and mathematics, acquired by professional education and related practical experience, and who is qualified to engage in the practice of corrosion control on metallic structures. Such person may be a licensed professional corrosion engineer or may be

1 Jan 99

certified as being qualified by NACE International if such licensing or certification includes suitable cathodic protection experience.

b. Workmanship. All material and equipment shall be installed in accordance with the requirements of the specifications and as recommended by the corrosion engineer and approved by the Contracting Officer. The installation, including testing, should be performed by an organization that has had at least 3 years experience in this type of work.

6-3. Operation and Maintenance

The reliability and effectiveness of any CPS depend upon the manner in which it is operated and maintained, as well as its proper design and installation.

a. Performance. The primary purpose for testing of a CPS is to determine if it has been optimized in accordance with and effectively meets design criteria. A system that does not meet this criteria will not adequately protect the structure against corrosion.

b. Operations and maintenance manual. An operations and maintenance manual should be provided for each CPS installed. This manual should provide instructions for testing and optimizing the system and should specify test equipment required. Copies of the structure-to-electrolyte potential measurements, obtained by the contractor at the time of acceptance of the system by the Government, should be included for reference. Blank data sheets should be provided for

Government test personnel to record data obtained in future periodic testing of the CPS.

c. Troubleshooting guide. A troubleshooting guide should be provided for use with the CPS. This guide should address possible symptoms associated with failure of various items of equipment of the system. Recommendations and possible solutions should also be included. If a problem cannot be resolved by the corrosion protection coordinator, then it is recommended that the designer seek the assistance addressed in Chapter 3 of this manual.

6-4. Restoration

Existing inoperable CPS's should be restored whenever possible and feasible. Restoration of a CPS should be part of the corrosion mitigation plan and should include, but not be limited to, the following:

a. A list of materials and cost.

b. An assessment of impact protection and consideration of the need for additional impact protection devices.

c. A survey indicating the status and functional condition of rectifiers, anodes, terminal cabinets, anode system cables, and impact devices.

d. A copy of the latest structure-to-reference-cell potential readings.

Chapter 7

Training and Services

7-1. Training

Training should be provided for project designers, inspectors, and operation and maintenance personnel who are responsible for CPS's in use at projects. Corrosion protection coordinators should arrange with District Training Coordinators for this training. The training should include both cathodic protection generally and report preparation. A PROSPECT course

on corrosion control is offered annually for district personnel. The course provides the required CPS training on design and testing.

7-2. Services

Services are available on a cost reimbursable basis to assist districts in training personnel and testing systems. Services are also available for design, restoration, construction, operation and maintenance, and optimization adjustments of CPS's. Services inquiries may be referred to CECW-ET, HQUSACE.

1 Jan 99

Appendix A

Sample Corrosion Mitigation Plan

CESAM-EN-CE

TO: Chief, Engineering Division

SUBJECT: Corrosion Mitigation Plan for Lock B Miter Gates, Tenn-Tom Waterway

1. **OBJECTIVE:** The objective of the subject plan is to provide methods for corrosion mitigation of the submerged metallic structural components of the Lock B miter gates.

2. **GENERAL:** Lock B miter gates are located in a submerged corrosive environment in which the water resistivity varies, but generally ranges between 40,000-60,000 ohm-mm. Galvanic corrosion of the structural components of the lock miter gates can, and often does, result in deterioration of the structural integrity of the gates. This deterioration can affect the operation of the gates and often requires expensive repair and/or replacement of the gate or its structural components. Weakening of the structural components of the gates may also cause failure of seals, failure of gate alignment, or failure of quoin and miter blocks and a general deterioration of the lock gates.

3. **CORROSION MITIGATION:** Corrosion of the metallic components of the gates can be extensively reduced by the proper preparation and application of corrosion inhibiting coatings to the gate surfaces. In addition, corrosion of the gates can be further reduced, and the life of the applied coatings extended, by the installation of cathodic protection systems (CPS's).

a. **Painting:**

(1) Preparation of the ferrous surfaces of the gates and structural members, and the selection and application of protective coatings, should be accomplished in accordance with the requirements of Civil Works Guide Specification CW-09940, "Painting; Hydraulic Structures and Appurtenant Works." The stringent requirements of the guide specification, including the Safety and Health Provisions detailed therein, should be adhered to.

(2) Ferrous surfaces of the gate structure should be cleaned to a grade approaching white metal grade in accordance with CW-09940. The surface anchor pattern shall be consistent with the recommendations of the coating manufacturer. Quality control should be in accordance with the requirements of this guide specification, and the method and minimum thickness of application of the protective coatings specified therein should be adhered to. Proper surface preparation is essential for achieving a good coating life.

b. **Impressed Current:** Installation of a CPS utilizing sacrificial anodes is considered an inadequate method for cathodically protecting the Lock B miter gates. Impressed current cathodic protection should therefore be applied using the guidance of CW-16643.

(1) A separate impressed current CPS should be provided for each gate leaf. Each system should consist of a rectifier supplying protective current to anodes which will distribute protective current to the gate structure. Cathodic protection should be installed on those portions of the gates submerged at normal pool levels. The faces of the gates should be protected to upper pool stages, except that the downstream

face of the lower gates should be protected to the lower pool. Meters should be provided as part of the rectifier for monitoring the voltage and current of the CPS.

(2) This navigation lock will be subject to flooding and floating debris; therefore, the CPS should be designed to permit for removal during periods of high water, and the anode cables and sausage-type anodes will require impact protection to prevent damage to the cables and anodes.

4. MAINTENANCE AND MONITORING: Maintenance and monitoring of the CPS (sacrificial or impressed current) are essential to ensure continued corrosion mitigation of the structure area under protection. The areas of the lock gates to receive cathodic protection are those areas of the gates already stipulated in paragraph 3b(1).

Monitoring and evaluations should be accomplished as follows:

a. The voltage and current readings of the rectifiers should be observed, monitored, and recorded daily. DC voltage and current data indicate that the rectifiers and CPS are working but do not guarantee that the system is properly optimized. Typical information on voltage and current data recordings is as follows:

<u>GATE</u>	<u>VOLTS</u>	<u>AMPS</u>
Upper - left leaf	14.5	.3
Upper - right leaf	14.2	.3
Lower - left leaf	11.4	.6
Lower - right leaf	10.8	.4

b. The evaluation of annual reference cell voltage data indicating the structure-to-electrolyte (lock-to-water) potential is the accepted method for determining the adequacy of corrosion protection provided by the CPS. Reference cell data are evaluated based on the design (anode locations), the voltage adjustments, and the adequacy of the test locations. Adjustments to the rectifier output can be made to improve the protective potentials applied to the gate leaves. Attached Table A-1 provides details on typical reference cell data.

(Name)
(Position)

TABLE A-1
(Impressed Current Installation)

RECTIFIER NO. 1
Upper Gate - Land Leaf - Upstream Side
Steel to Half-Cell Potentials
Reports Control Symbol ENGW-E-7
Date of test: 1 Oct. 1991

Depth Below Water Surface mm	Pre-Protection			Current On			Current Off		
	Quoin End	Middle	Miter End	Quoin End	Middle	Miter End	Quoin End	Middle	Miter End
150	-0.500	-0.505	-0.495	-1.050	-1.000	-1.055	-0.655	-0.700	-0.650*
600	-0.500	-0.500	-0.500	-1.040	-1.030	-1.035	-0.700	-0.735	-0.705
1200	-0.500	-0.500	-0.500	-1.050	-1.085	-1.050	-0.825	-0.755	-0.815
1850	-0.500	-0.495	-0.495	-1.050	-1.100	-1.055	-0.855	-0.765	-0.850
2450	-0.495	-0.490	-0.490	-1.050	-1.085	-1.050	-0.865	-0.770	-0.850
3050	-0.490	-0.480	-0.485	-1.080	-1.110	-1.070	-0.880	-0.880	-0.850**
3650	-0.490	-0.480	-0.480	-1.070	-1.080	-1.060	-0.885	-0.880	-0.880
4250	-0.480	-0.479	-0.470	-1.070	-1.070	-1.065	-0.880	-0.885	-0.980
4900	-0.470	-0.464	-0.460	-1.000	-1.020	-1.030	-0.885	-0.890	-0.980
5500	-0.465	-0.455	-0.450	-1.000	-0.979	-1.050	-0.880	-0.885	-0.985
6100	-0.460	-0.445	-0.440	-0.950	-0.930	-1.000	-0.870	-0.875	-0.1075
<div> <div> Rectifier voltage = 2.10 volts Rectifier current = 0.50 amps Coarse tap position = L Fine tap position = 2 Meter used 5 meg ohms/volt 2 volt scale Half-cell 75 mm or less from lock steel Resistance of circuit: $E = IR$ $2.10 = .5R$ $R = 2.10/.5 = 4 \text{ ohms}$ </div> <div> NOTE: Include as many 600-mm (2-ft) increments as necessary to cover submerged depth of gate * Unacceptable reading ** Acceptable reading </div> </div>									

Appendix B

Detailed Cathodic Protection Design Procedures for Pike Island Auxiliary Lock Gates

DESIGNS FOR LOCK GATES

Figure B1 shows a Pike Island auxiliary miter gate. This gate is approximately 18.85 m (62 ft) long and 10.64 m (35 ft) high. With the river at normal water level, portions of each gate will always be submerged, and other portions may be submerged or exposed as lockages occur. During times of high water, more gate surfaces will be submerged, and, under conditions of flood, the entire gates may be submerged. The usual water depth is 9.12 m (30 ft).

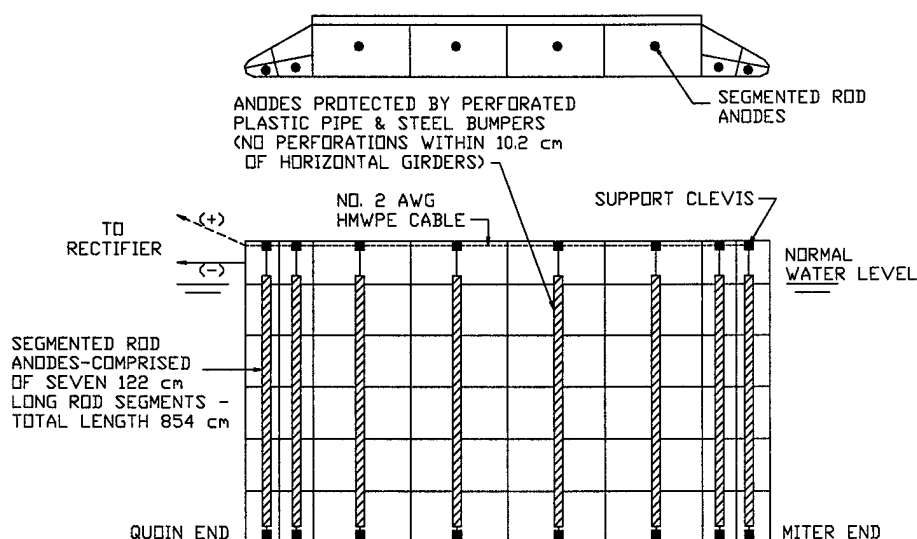


Figure B1. Pike Island auxiliary lock miter gate

The gates are constructed of welded structural steel, horizontally framed, with a cast pintle. The downstream side of the gate consists of a pattern of rectangular chambers closed on five faces and open to the water on the sixth face. The upstream face of the gate is made up of a large skin plate over the major portion of the face and two columns of small chambers at the quoin and miter ends of the gate.

The main (large) chambers on the downstream face of the gate are set in four columns and are approximately 3.66 m (12 ft) wide, varying in height from 1.01 m (3 ft 4 in.) to 1.82 m (6 ft), with a depth of 1.06 m (3 ft 6 in.). The two sets of vertically aligned chambers, at the quoin and miter ends of the gates, are much smaller and irregularly shaped. There are 6 horizontally aligned rows of chambers placed one above the other in each vertical column, giving a total of 48 chambers on the downstream side.

Design Data

- a.* The lock is located in fresh water with a resistivity of 3000 ohm-centimeters.
- b.* Water velocity is less than 1524 mm/s (5 ft/s).
- c.* Water contains debris, and icing will occur in the winter.
- d.* The gate surfaces have a new vinyl paint coating, minimum of 0.15 mm (6 mils) thick, with not more than 1 percent of the area bare because of holidays in the coating.
- e.* The coating will deteriorate significantly in 20 years of exposure. Experience shows that 30 percent of the area will become bare in 20 years.
- f.* Design for 75.35 mA/m^2 (7.0 mA/ft^2) (moving fresh water).
- g.* Electric power is available at 120/240 volts AC, single phase at the lock site.
- h.* Design for a 20-year life.
- i.* Design for entire surface of the gate to be submerged.
- j.* Base anode requirement on the average current requirement over the anode design life.
- k.* Base rectifier requirement on maximum (final) current requirement at end of anode design life.

Computations

1) Find the surface area to be protected.

A) Upstream side

Area of skin plate: $14.51 \text{ m} \times 10.67 \text{ m} = 154.82 \text{ m}^2$ (1666 ft^2)

Chamber areas at each end (same at each end):

6 chambers @ $6.50 \text{ m}^2 = 39.02 \text{ m}^2$ (420 ft^2)

6 chambers @ $3.72 \text{ m}^2 = 22.30 \text{ m}^2$ (240 ft^2)

6 chambers in each vertical column

B) Downstream side

Number of Chambers	Chamber Area m^2 (ft^2)	Total Area m^2 (ft^2)
4	5.85 (63)	23.41 (252)
4	6.60 (71)	26.34 (284)
4	7.06 (76)	28.24 (304)
4	8.08 (87)	32.33 (348)
4	8.55 (92)	34.19 (368)
4	13.47 (145)	53.88 (580)
4	14.68 (158)	58.71 (632)
4	15.51 (167)	62.06 (668)
4	16.63 (179)	66.52 (716)
2	17.28 (186)	34.56 (372)
4	18.12 (195)	72.46 (780)
2	19.14 (206)	38.28 (412)
2	21.18 (228)	42.36 (456)
2	22.20 (239)	44.40 (478)
Total number of chambers = 48 Total chamber area = 194.17 m^2 (2092 ft^2) Total area = 617.81 m^2 (6650 ft^2)		

2) Calculate the current requirements (I) from Equation 1.

$$I = A * I' (1.0 - C_E) \quad [\text{EQ 1}]$$

where

A = surface area to be protected (varies depending on portion of structure)

I' = required current density to adequately protect gate 75.35 mA/m²

C_E = coating efficiency (0.99 initial, and 0.70 final)

A) Upstream side

Skin plate current requirement

Calculate I

where A = 154.82 m² (1666 ft²) (from computation step 1A).

Initial current requirement (C_E = 99%):

$$I = 154.82 \text{ m}^2 \times 75.35 \text{ mA/m}^2 \times (1 - 0.99) = 116 \text{ mA (use 120 mA)}$$

Final current requirement (C_E = 70%):

$$I = 154.82 \text{ m}^2 \times 75.35 \text{ mA/m}^2 \times (1 - 0.70) = 3498 \text{ mA (use 3500mA)}$$

Average current requirement:

$$I = (120 + 3500)/2 \text{ mA} = 1810 \text{ mA (use step 2A for skin plate)}$$

End chamber current requirement

To be able to use the same anode assembly in each set of chambers, base the design on the larger of the two chambers at each end.

Calculate I

where A = 39.02 m² (420 ft²) (from computation step 1A).

Initial current requirement (C_E = 99%):

$$I = 39.02 \text{ m}^2 \times 75.35 \text{ mA/m}^2 \times (1 - 0.99) = 29.4 \text{ mA (use 30 mA for 6 chambers)}$$

Final current requirement (C_E = 70%):

$$I = 39.02 \text{ m}^2 \times 75.35 \text{ mA/m}^2 \times (1 - 0.70) = 882 \text{ mA (use 900 mA per 6 chambers)}$$

Average current requirement:

$$I = (30 + 900)/2 = 465 \text{ mA per 6 chambers (use 0.5 per 6 chambers in a vertical column).}$$

This is current requirement for one vertical column of 6 chambers. Total average current requirement is four times this amount:

$$I = 0.5 \times 4 = 2.0 \text{ A for chamber}$$

Total current requirement (I_T) for upstream side:

$$I_T = 120 \text{ mA} + (4 \times 30 \text{ mA}) = 240 \text{ mA} = 0.24 \text{ amps (initial)}$$

$$I_T = 2.0 \text{ A} + 2.0 \text{ A} = 4.0 \text{ amperes (average)}$$

$$I_T = 3500 \text{ mA} + (4 \times 900 \text{ mA}) = 7100 \text{ mA} = 7.10 \text{ amps (final)}$$

B) Downstream side

Calculate I

where $A = 22.20 \text{ m}^2$ (239 ft^2) (from computational step 1B).

Initial current requirement ($C_E = 99\%$):

$$I = 22.20 \text{ m}^2 \times 75.35 \text{ mA/m}^2 \times (1 - 0.99) = 16.8 \text{ mA per chamber}$$

Final current requirement ($C_E = 70\%$):

$$I = 22.20 \text{ m}^2 \times 75.35 \text{ mA/m}^2 \times (1 - 0.70) = 502 \text{ mA per chamber}$$

Average current requirement:

$$I = (16.8 + 502)/2 = 260 \text{ mA per chamber}$$

Total current requirement for downstream side (48 chambers):

$$I_T = 16.8 \text{ mA/chamber} \times 48 \text{ chamber} = 806 \text{ mA} = 0.8 \text{ A (initial)}$$

$$I_T = 260 \text{ mA/chamber} \times 48 \text{ chamber} = 12,480 \text{ mA} = 12.4 \text{ A (average)}$$

$$I_T = 502 \text{ mA/chamber} \times 48 \text{ chamber} = 224,096 \text{ mA} = 24.2 \text{ A (final)}$$

C) Total current requirement

Initial

$$\text{Upstream side} = 0.24 \text{ amps}$$

$$\text{Downstream side} = \underline{0.80 \text{ amps}}$$

$$1.04 \text{ amps}$$

Average

Upstream side = 4.0 amps
Downstream side = 12.4 amps
16.4 amps

Final

Upstream side = 7.1 amps
Downstream side = 24.2 amps
31.3 amps

Note: Average current requirements determine anode selection. Final current requirements determine rectifier selection.

3) Select the anode and calculate the number of anodes required (N) to meet the design life requirements.

Disk anodes such as those shown in Figure B2 are considered best for the skin plate on the upstream side. Either 3.2-mm- (1/8-in.-) diam segmented rod anodes consisting of 1,219-mm (4-ft) segments, as shown in Figure B3, or continuous 3.2-mm- (1/8-in.-) diam prefabricated rod anodes are considered best for the chambers.

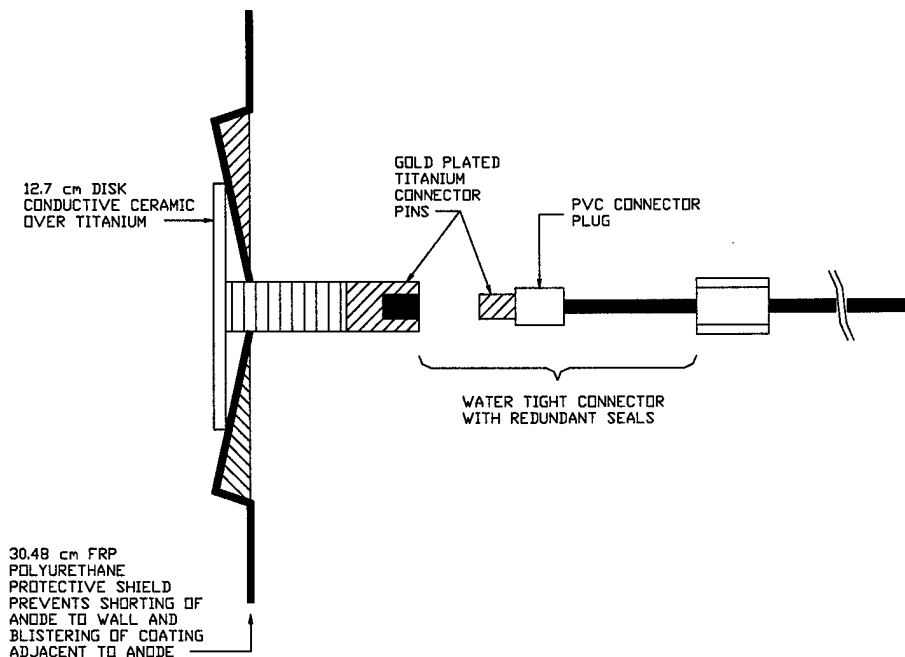


Figure B2. Typical ceramic-coated flat disk anode

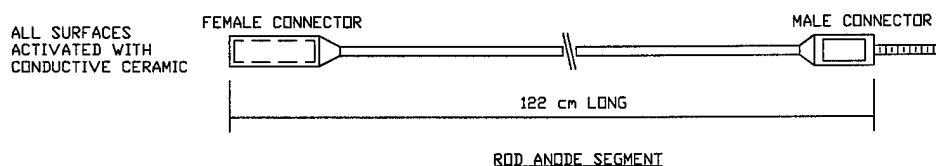


Figure B3. Typical ceramic-coated rod anode design

For this example, the design based on the 1219-mm (4-ft) segments. The design for the continuous rod material would be identical since they have the same amperage capacity per lineal foot of anode material. Number of anodes is calculated from Equation 2.

$$N = \frac{I}{I_A} \quad [\text{EQ 2}]$$

where

I = total current requirement

I_A = average current per anode for the anode's desired life.

A) Upstream side

Skin plate - number of disk anodes

Calculate N

where $I = 2 \text{ A}$ (from step 2A)

$I_A = 0.84 \text{ A/disk anode}$

$$N = \frac{2}{0.84} = 2.4 \text{ anodes; use 3 disk anodes}$$

Chambers - number of segmented rod anodes

For each set of 6 chambers in a vertical column

Calculate N

where $I = 0.5 \text{ A}$ (from step 2A)

$I_A = 1.0 \text{ A/1219-mm- (4-ft-) long segmented rod}$ (from Table B-1M (Metric)/B-1 (U.S. Customary))

$$N = \frac{0.5}{1} = 0.5 \text{ anodes; use 1 segmented rod anode per 6 vertical chambers}$$

B) Downstream side

$$I = 260 \text{ mA per chamber}$$

For each set of 6 chambers in a vertical column

$$I = 6 \times 260 \text{ mA} = 1560 \text{ mA} = 1.56 \text{ A}$$

$$I_A = 1.0 \text{ A/anode (from Table B-1M/B-1)}$$

$$N = \frac{1.56}{1} = 1.56 \text{ anodes; use 2 segmented rod anodes per 6 vertical chambers}$$

4) Select number of anodes to provide adequate current distribution.

A) Upstream side

Skin plate

Experience shows that an anode grid spacing of 3.048 to 3.658 m (10 to 12 ft) provides adequate coverage of protective current. Additional anodes are also needed along the bottom of the gate, as this is an area where coating damage occurs readily, thus exposing an appreciable amount of bare metal. Figure B4 shows a suitable configuration using a combination of 19 disk anodes.

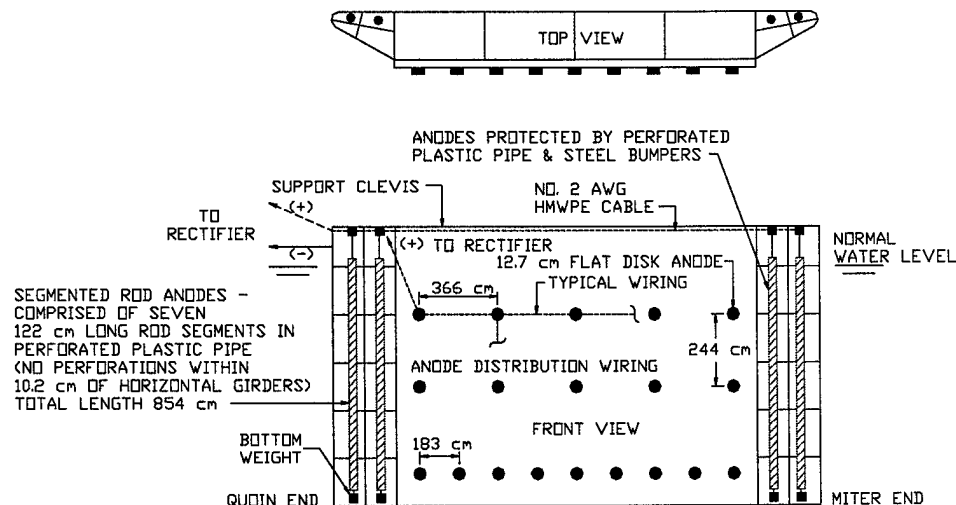


Figure B4. Auxiliary lock miter gate design at Pike Island

Table B-1M (Metric)
Dimensions and Ratings of Ceramic Anodes
Underground Usage

Wire and Rod Anodes (Packaged)

Anode Element Dimension mm x mm	Package Size mm	Weight kg	Current Rating, amps				
			10-Year Design Life	15-Year Design Life		20-Year Design Life	
				HDC	SC	HDC	SC
3.2 x 610	51 x 762	13.22	1.3	1.10	0.6	0.9	0.5
1.6 x 1524	51 x 1829	30.86	1.5	1.25	0.7	1.0	0.6
1.6 x 1524	76 x 1829	57.32	1.5	1.25	0.7	1.0	0.6
3.2 x 1219	51 x 1524	26.45	2.7	2.2	1.2	1.8	1.0
3.2 x 1219	76 x 1524	48.50	2.7	2.2	1.2	1.8	1.0
6.4 x 1219	76 x 1524	48.50	5.5	4.4	2.4	3.5	2.0
3.2 x 1829	76 x 2438	77.16	4.0	3.3	1.8	2.7	1.5
9.5 x 1219	76 x 1524	48.50	7.5	6.0	3.6	5.1	3.0
12.7 x 1219	76 x 1524	50.70	10.0	8.0	4.8	6.8	4.0
19 x 1219	76 x 1524	55.11	15.0	12.0	7.2	10.0	6.0
3.2 x 1829	76 x 2438	77.16	4.0	3.3	1.8	2.7	1.5
6.4 x 1829	76 x 2438	77.16	8.2	6.6	3.6	5.3	3.0
3.2 x 2438	76 x 3048	97.00	5.4	4.4	2.4	3.6	2.0
6.4 x 2438	76 x 3048	97.00	11.0	8.8	4.8	7.0	4.0
Note: HDC = heavy duty coating tubular anodes (in coke breeze). SC = standard coating tubular anodes (in coke breeze).							

Anode Element Dimension, mm x mm	20-Year Design Life Current Rating, amps
25.4 x 250	2.00
25.4 x 500	4.00
25.4 x 1000	8.00
16 x 250	1.25
16 x 500	2.50
16 x 1000	5.00

Table B-1M (Cont'd)
Fresh and Seawater Usage

Wire and Rod Anodes (Bare)

Life (years)	Fresh Water	Brackish Water	Seawater
Maximum Current(A)/305-mm Length for 20-Year Design Life of 1.6-mm-diam Wire			
10	0.39	0.51	0.85
15	0.31	0.44	0.74
20	0.26	0.39	0.67
Maximum Current(A)/305-mm Length for 20-Year Design Life of 3.2-mm-diam Rod or Wire			
10	0.79	1.02	1.7
15	0.62	0.88	1.47
20	0.52	0.79	1.33
Maximum Current(A)/305-mm Length for 20-Year Design Life of 6.4-mm-diam Rod			
10	1.58	2.04	3.41
15	1.24	1.76	2.95
20	1.04	1.58	2.66
Maximum Current(A)/305-mm Length for 20-Year Design Life of 8.3-mm-diam Rod			
10	2.37	3.06	5.11
15	1.85	2.63	4.42
20	1.56	2.37	3.99
Maximum Current(A)/305-mm Length for 20-Year Design Life of 12.7-mm-diam Rod			
10	3.16	4.08	6.81
15	2.47	3.51	5.9
20	2.08	3.16	5.33
Maximum Current(A)/305-mm Length for 20-Year Design Life of 15.9-mm-diam Rod			
10	3.95	5.1	8.52
15	3.09	4.39	7.37
20	2.6	3.95	6.66
Maximum Current(A)/305-mm Length for 20-Year Design Life of 19-mm-diam Rod			
10	4.74	6.12	10.22
15	3.71	5.27	8.85
20	3.12	4.74	7.99

Table B-1M (Cont'd)
Fresh and Seawater Usage

Tubular Anodes (Bare)

Seawater - Current in amps per anode (15-year design life)	
25.4 mm x 500 mm	25 amps
25.4 mm x 1000 mm	50 amps
16 mm x 500 mm	15 amps
16 mm x 1000 mm	30 amps
Sea Mud - Current in amps per anode (20-year design life)	
25.4 mm x 500 mm	6 amps
25.4 mm x 1000 mm	12 amps
Fresh Water - Current in amps per anode (20-year design life)	
25.4 mm x 500 mm	4.00 amps
25.4 mm x 1000 mm	8.00 amps
16 mm x 500 mm	2.50 amps
16 mm x 1000 mm	5.00 amps

Current Density Limitations

Wire and Rod Anode

Anode Life Versus Maximum Current Density (amps per 0.0929 m²)

Life, years	Coke	Fresh Water	Brackish Water	Seawater
10	19	24	31	52
15	15	19	27	45
20	13	16	24	41

Tubular Anodes

Anode Life Versus Maximum Current Density (amps per 0.0929 m²)

Life, years	Fresh Water	Brackish Water	Seawater
20	9.3	9.3	56

Table B-1M (Concluded)

Disk Anodes (see Figure B2)

Size: 127 mm diam (typical - other sizes available) Active Area: 12,258 mm ² Weight: 907 g		
	Fresh Water	Salt Water
Current capacity - 20-year life (amps/anode)	0.84	5.00
Operating voltage - 20-year life (V)	20.0	10.0

Segmented Rod Anodes (see Figure B3)

Size: 1219-mm length; 3.5-mm diam Active Area: 14,194 mm ² Weight: 65 g		
	Fresh Water	Salt Water
Current capacity - 20-year life (amps/anode)*	1.00	2.50
Operating voltage - 20-year life (V)	50.0	10.0

*Standard coating

Table B-1(U.S. Customary)
Dimensions and Ratings of Ceramic Anodes
Underground Usage

Wire and Rod Anodes (Packaged)

Anode Element Dimension	Package Size, in.	Weight lb	Current Rating, amps				
			10-Year Design Life	15-Year Design Life		20-Year Design Life	
				HDC	SC	HDC	SC
1/8" x 2'	2 x 30	6	1.3	1.10	0.6	0.9	0.5
1/16" x 5'	2 x 72	14	1.5	1.25	0.7	1.0	0.6
1/16" x 5'	3 x 72	26	1.5	1.25	0.7	1.0	0.6
1/8" x 4'	2 x 60	12	2.7	2.2	1.2	1.8	1.0
1/8" x 4'	3 x 60	22	2.7	2.2	1.2	1.8	1.0
1/4" x 4'	3 x 60	22	5.5	4.4	2.4	3.5	2.0
1/8" x 6'	3 x 96	35	4.0	3.3	1.8	2.7	1.5
3/8" x 4'	3 x 60	22	7.5	6.0	3.6	5.1	3.0
1/2" x 4'	3 x 60	23	10.0	8.0	4.8	6.8	4.0
3/4" x 4'	3 x 60	25	15.0	12.0	7.2	10.0	6.0
1/8" x 6'	3 x 96	35	4.0	3.3	1.8	2.7	1.5
1/4" x 6'	3 x 96	35	8.2	6.6	3.6	5.3	3.0
1/8" x 8'	3 x 120	44	5.4	4.4	2.4	3.6	2.0
1/4" x 8'	3 x 120	44	11.0	8.8	4.8	7.0	4.0
Note: HDC = heavy duty coating tubular anodes (in coke breeze). SC = standard coating tubular anodes (in coke breeze).							

Anode Element Dimension	20-Year Design Life Current Rating, amps
1" x 9.8"	2.00
1" x 19.7"	4.00
1" x 39.4"	8.00
0.63" x 9.8"	1.25
0.63" x 19.7"	2.50
0.63" x 39.4"	5.00

Table B-1 (Cont'd)
Fresh and Seawater Usage

Wire and Rod Anodes (Bare)

Life (years)	Fresh Water	Brackish Water	Seawater
Maximum Current/l-ft Length for 20-Year Design Life of .0625-in.-diam Wire			
10	0.39	0.51	0.85
15	0.31	0.44	0.74
20	0.26	0.39	0.67
Maximum Current/l-ft Length for 20-Year Design Life of .125-in.-diam Rod or Wire			
10	0.79	1.02	1.7
15	0.62	0.88	1.47
20	0.52	0.79	1.33
Maximum Current/l-ft Length for 20-Year Design Life of .25-in.-diam Rod			
10	1.58	2.04	3.41
15	1.24	1.76	2.95
20	1.04	1.58	2.66
Maximum Current/l-ft Length for 20-Year Design Life of .325-in.-diam Rod			
10	2.37	3.06	5.11
15	1.85	2.63	4.42
20	1.56	2.37	3.99
Maximum Current/l-ft Length for 20-Year Design Life of .5-in.-diam Rod			
10	3.16	4.08	6.81
15	2.47	3.51	5.9
20	2.08	3.16	5.33
Maximum Current/l-ft Length for 20-Year Design Life of .625-in.-diam Rod			
10	3.95	5.1	8.52
15	3.09	4.39	7.37
20	2.6	3.95	6.66
Maximum Current/l-ft Length for 20-Year Design Life of .75-in.-diam Rod			
10	4.74	6.12	10.22
15	3.71	5.27	8.85
20	3.12	4.74	7.99

Table B-1 (Cont'd)
Fresh and Seawater Usage

Tubular Anodes (Bare)

Seawater - Current in amps per anode (15-year design life)	
1 in. x 19.7 in.	25 amps
1 in. x 39.4 in.	50 amps
0.63 in. x 19.7 in.	15 amps
0.63 in. x 39.4 in.	30 amps
Sea Mud - Current in amps per anode (20-year design life)	
1 in. x 19.7 in.	6 amps
1 in. x 39.4 in.	12 amps
Fresh Water - Current in amps per anode (20-year design life)	
1 in. x 19.7 in.	4.00 amps
1 in. x 39.4 in.	8.00 amps
0.63 in. x 19.7 in.	2.50 amps
0.63 in. x 39.4 in.	5.00 amps

Current Density Limitations

Wire and Rod Anode

Anode Life Versus Maximum Current Density (amps/sq ft)

Life, years	Coke	Fresh Water	Brackish Water	Seawater
10	19	24	31	52
15	15	19	27	45
20	13	16	24	41

Tubular Anodes

Anode Life Versus Maximum Current Density (amps/sq ft)

Life, years	Fresh Water	Brackish Water	Seawater
20	9.3	9.3	56

Table B-1 (Concluded)

Disk Anodes (see Figure B2)

Size: 5-in. diam (typical - other sizes available) Active Area: 19 sq in. Weight: 2.0 lb		
	Fresh Water	Salt Water
Current capacity - 20-year life (amps/anode)	0.84	5.00
Operating voltage - 20-year life (V)	20.0	10.0

Segmented Rod Anodes (see Figure B3)

Size: 4-ft length; 0.138-in. diam Active Area: 22 sq in. Weight: 2.3 oz		
	Fresh Water	Salt Water
Current capacity - 20-year life (amps/anode)*	1.00	2.50
Operating voltage - 20-year life (V)	50.0	10.0

*Standard coating

Chambers

A continuous length of screw-coupled segmented rod anodes is needed for each chamber column at the miter and quoin ends extending from the high-water line down to within 610 mm (2 ft) of the bottom girder. Each anode consists of 7 segments, each 1219 mm (4 ft) in length. Four segmented rod anode assemblies are thus required, comprising a total of 28 segments, each 1219 mm (4 ft) in length. See Figure B5.

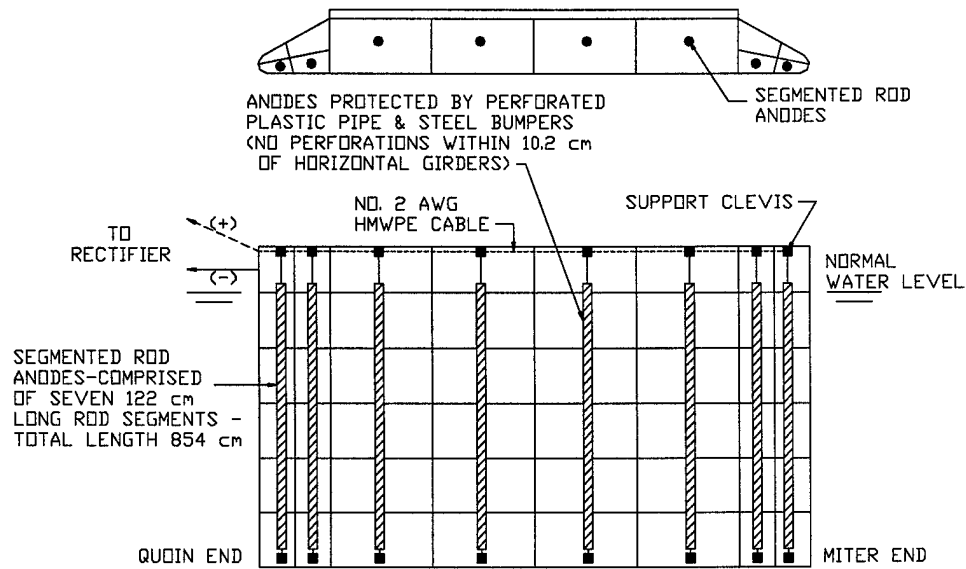


Figure B5. Auxiliary lock miter gate at Pike Island showing rod anode placement

Total anodes required for the upstream side:

- 19 disk anodes
- 4 segmented rod anodes (28 individual rod segments)

B) Downstream side

One continuous length of screw-coupled segmented rod anodes is needed for each chamber column extending from the high-water line down to within 610 mm (2 ft) of the bottom girder. (Note: For the downstream side of the downstream gates, a much shorter anode length will be required since only the lower portions of this gate surface are ever submerged.) Each anode rod consists of 7 segments, each 1219 mm (4 ft) in length. Eight segmented rod anodes are thus required, comprising a total of 56 segments, each 1219 mm (4 feet) in length. See Figure B5.

5) Determine the anode-to-water resistance (R_A) of the individual anodes.

Disk anodes

Empirical information indicates anode-to-water resistance (R_A) of a single 127-mm (5-in.) disk anode on a coated structure may be expressed by Equation 3.

$$R_A = \frac{p}{21.5} \quad [\text{EQ 3}]$$

where $p = 3000$ ohm-cm (water resistivity from design item 1)
21.5 = Manufacturer correlation constant for 127-mm flat disk anode used to yield ohms

$$R_A = \frac{3000}{21.5} = 139.5 \text{ ohms}$$

The disk anode-to-water resistance (R_N) of the 19 disk anodes can be approximated from Equation 4.

$$R_N = R_A / N + (p * P_F) / C_C \quad [\text{EQ 4}]$$

where: $R_A = 139.5$ ohms (disk anode-to-water resistance of individual disk anodes from previous calculation)
 $N = 19$ (number of anodes, design step 4)
 $p = 3000$ ohm-cm
 $P_F = 0.0427$ (paralleling factor from Table B-2M (metric)/B-2 (U.S. customary))
 $C_C = 304.8$ cm (10 ft) (center-to-center spacing of disc anodes).

$$R_N = 139.5/19 + (3000 \times 0.0427)/(304.8 \text{ cm}) = 7.7 \text{ ohms}$$

At the maximum expected current of 3500 mA (3.5 amps), the voltage required for the disk anodes can be determined using Ohm's Law, Equation 5.

$$E = I \times R \quad [\text{EQ 5}]$$

$$E = 3.5 \times 7.7 = 27 \text{ volts}$$

This is a reasonable voltage, so the 19 disk anodes are sufficient

Segmented rod anodes

The segmented rod anode-to-water resistance (R_A) is calculated from Equation 6. the total length of anode is used, although a shorter length could be used if low water conditions were expected most of the time.

$$R_A = \frac{K \times p}{L} \times [\ln(8L/d) - 1] \quad [\text{EQ 6}]$$

1 Jan 99

where

p = 3000 ohm-cm (water resistivity from design item 1)

L = 853 cm (28 ft) (length of anode rod from design step 4)

d = 0.35 cm (0.0115 ft) (anode rod diameter)

K = 0.158 (metric)

K = 0.0052 (U.S. customary)

$$R_A = \frac{0.158 \times 3000}{853} \times \left(\ln \frac{8 \times 853}{0.35} - 1 \right)$$

$$R_A = 0.557 (9.88 - 1) = 4.95 \text{ ohms}$$

Table B-2M (Metric)
Anode Paralleling Factors for Various Number of
Anodes Installed in Parallel

N	P	N	P
2	0.0796	14	0.0512
3	0.0881	16	0.0472
4	0.0863	18	0.0442
5	0.0817	20	0.0411
6	0.0768	22	0.0390
7	0.0722	24	0.0369
8	0.0683	26	0.0347
9	0.0646	28	0.0332
10	0.0613	30	0.0317
12	0.0555		

Note: N = number of anodes; P = paralleling factors

Table B-2 (U.S. Customary)
Anode Paralleling Factors for Various Number of
Anodes Installed in Parallel

N	P	N	P
2	0.00261	14	0.00168
3	0.00289	16	0.00155
4	0.00283	18	0.00145
5	0.00268	20	0.00135
6	0.00252	22	0.00128
7	0.00237	24	0.00121
8	0.00224	26	0.00114
9	0.00212	28	0.00109
10	0.00201	30	0.00104
12	0.00182		

Note: N = number of anodes; P = paralleling factors

Voltage for upstream side rod anodes

At the maximum expected current requirement for the upstream chambers of 900 mA per vertical column of 6 chambers, the voltage required for each rod anode can be determined using Ohm's Law, Equation 5.

$$E = I \times R = 0.90 \text{ amps} \times 4.95 \text{ ohms} = 4.46 \text{ volts}$$

This is a reasonable voltage, so the single anode per column of chambers is sufficient.

Voltage for downstream side rod anodes

At the maximum expected current of 251 mA per chamber, the current required for one vertical column of 6 chambers is:

$$I = 6 \times 502 \text{ mA} = 3012 \text{ mA or } 3.0 \text{ amperes}$$

The voltage required for each anode is found using Equation 5:

$$E = I \times R = 3.0 \text{ amps} \times 4.95 \text{ ohms} = 14.9 \text{ volts}$$

This is a reasonable voltage, so the single anode per vertical column of chamber is sufficient.

6) Determine total circuit resistance (R_T) using Equation 7.

$$R_T = R_N + R_W + R_C \quad [\text{EQ 7}]$$

where: R_N = anode-to-water resistance
 R_W = header cable/wire resistance
 R_C = tank-to-water resistance

A) Upstream side

Skin Plate

$R_N = 7.7 \text{ ohms (anode-to-water resistance)}$
 $R_W = 0.02 \text{ ohms (wire resistance)}$

R_W depends on the actual wiring of the anodes, but the general arrangement would be to use a header cable from the rectifier to the center of the disk anode array and then distribute the current through a junction box to each anode. Wiring would be in a conduit on the inside of the gate. Assuming the rectifier is 8.53 m (28 ft) from the gate, there will be about 30.48 m (100 ft) of positive and negative header cable. No. 2 AWG, HMWPE insulated cable is selected. The resistance of the anode distribution wiring is considered negligible. The header cable resistance is calculated from Equation 8.

$$R_w = \frac{L_w R_{MFT}}{1000} \quad [EQ 8]$$

where $L_w = 30.48 \text{ m (100 ft)}$ (header cable length (as noted above))
 $R_{MFT} = 0.159 \text{ ohms}$ (resistance per 304.8 m (1000 linear ft) of No. 2 AWG HMWPE)

$$R_w = \frac{30.48 \times 0.159}{304.8} = 0.016 \text{ ohms; use } 0.02 \text{ ohms}$$

$$R_C = 0.00 \text{ ohms (structure-to-water resistance)}$$

R_C is considered negligible since the design maximum capacity is based on a 30 percent bare structure which would have negligible resistance.

The total resistance R_T of the skin plate disk anode system using Equation 7 is:

$$R_T = R_N + R_w + R_C = 7.7 + 0.02 + 0.0 = 7.72 \text{ ohms}$$

Chambers

Total resistance of the 4 upstream chamber anodes (R_N) is calculated as follows: The 4 anode rods are in parallel. Total resistance can be determined from the law of parallel circuits. Since all 4 anodes have the same anode-to-water resistance, the calculation becomes Equation 9.

$$R_N = R_A / N = 4.95 / 4 = 1.24 \text{ ohms} \quad [EQ 9]$$

where: R_N = total resistance of all 4 anodes
 $R_A = 4.95$ (anode-to-water resistance)
 $N = 4$ (number of anodes)

$$R_w = 0.01 \text{ ohms (wire resistance)}$$

R_w consists of a No. 2 AWG, HMWPE insulated cable. The rectifier will be located about 7.62 m (25 ft) from the gate, requiring 15.24 m (50 ft) of positive and negative header cable to the gate.

There will be about 18.29 m (60 ft) of cable on the gate. One half of the cable resistance is used in the calculation to allow for distribution of current.

$$\text{Total wire length then is: } 15.24 \text{ m} + 9.14 \text{ m} = 24.38 \text{ m (80 ft)}$$

Resistance, R_w , is calculated from Equation 8:

$$R_w = \frac{L_w R_{MFT}}{1000} \quad [EQ 8]$$

where: $L_w = 24.38$ m (80 ft) (header cable length (as noted above))
 $R_{MFT} = 0.159$ ohms (resistance per 304.8 m (1000 linear ft) of No. 2 AWG HMWPE)

$$R_w = \frac{24.38 \times 0.159}{304.8} = 0.01 \text{ ohms}$$

$R_C = 0.00$ ohms (structure-to-water resistance is negligible)

Total resistance (R_T) of the upstream chamber system then from Equation 7:

$$R_T = R_N + R_w + R_C \quad [EQ 7]$$

$$R_T = 1.24 + 0.01 + 0.0 = 1.25 \text{ ohms}$$

B) Downstream side

Calculations are similar to those from the upstream chambers. Anode-to-water resistance, R_N , from Equation 9 is:

$$R_N = R_A / N$$

where: $R_A = 4.95$ ohms (from design step 5).
 $N = 8$ anode rods (from design step 3).

$$R_N = 4.95 / 8 = 0.62 \text{ ohms}$$

$R_w = 0.01$ ohms wire resistance (wire length and resistance is the same as the upstream side).

Total resistance (R_T) from Equation 7:

$$R_T = R_N + R_w + R_C = 0.62 + 0.01 + 0.0 = 0.63 \text{ ohms}$$

7) Determine required rectifier voltage (V_{REC}) and current.

A) Upstream side

Skin plate

Maximum current required: 3.50 A (step 2A)
Resistance: 7.72 ohms (from step 6A)

Voltage required, Equation 5: $E = I \times R = 3.5 \times 7.72 = 27$ volts

Chambers

Maximum current required: 3.6 amperes (from step 2A)

Resistance: 7.72 ohms (from step 6A)

Voltage required, Equation 5: $E = I \times R = 3.6 \times 1.25 = 4.5$ volts

B) Downstream side

Maximum current required: 24.2 amperes (from step 2B)

Resistance: 0.63 ohms (from step 6B)

Voltage required, Equation 5: $E = I \times R = 24.2 \times 0.63 = 15.3$ volt

Selection of Rectifier

The largest design voltage requirement is 27 volts. Using a factor of safety of 120 percent, rectifier voltage is calculated:

$$27 \text{ volts} \times (120\%) = 33 \text{ volts}$$

Total current required:

Upstream skin plate	= 3.50 amperes
Upstream chambers	= 7.1 amperes
Downstream chambers	= <u>24.2 amperes</u>
	34.8 amperes

For a commercially available rectifier having an output of 40 volts, 40 amperes is chosen. Because of the different circuit resistances, separate control over each circuit is required. This is best handled by a rectifier having 3 separate automatic constant current output circuits. Figure B6 shows the circuitry.

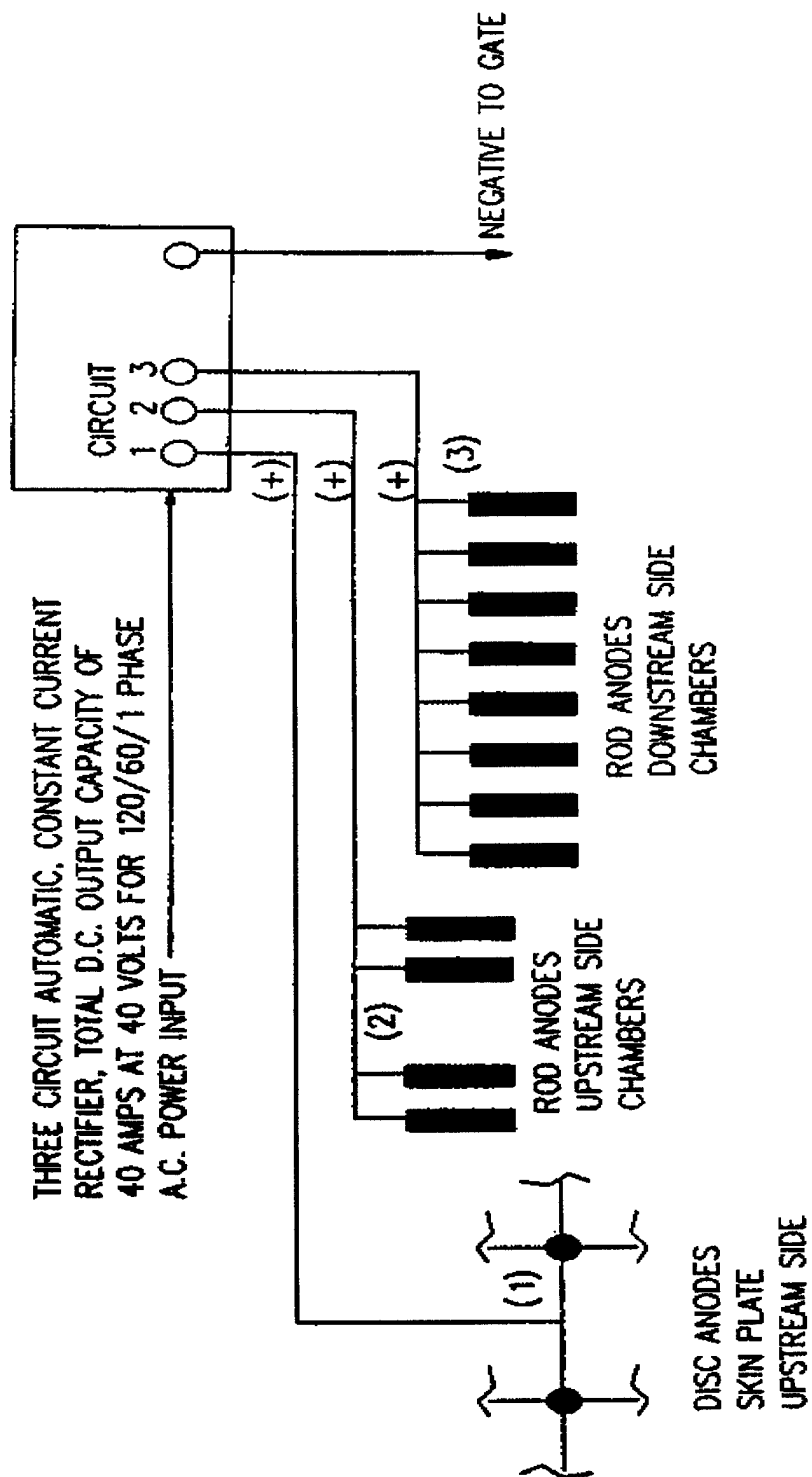


Figure B6. Circuit diagram lock miter gate

Rod Anode Installation

Rod anodes can be supported by the cable from a clevis at the top of the gate. Since ice and debris are expected, the anodes need to be protected. This is best done by installing them within perforated polyethylene or fiberglass pipes. A steel half-pipe bumper is used outside the plastic pipe. The anodes may be secured at the bottom using a stabilizing weight or stand off device.

Other Gate Applications

Anode configurations for a Cordell Hull tainter gate and a Cape Canaveral sector gate are shown in Figures B7 and B8.

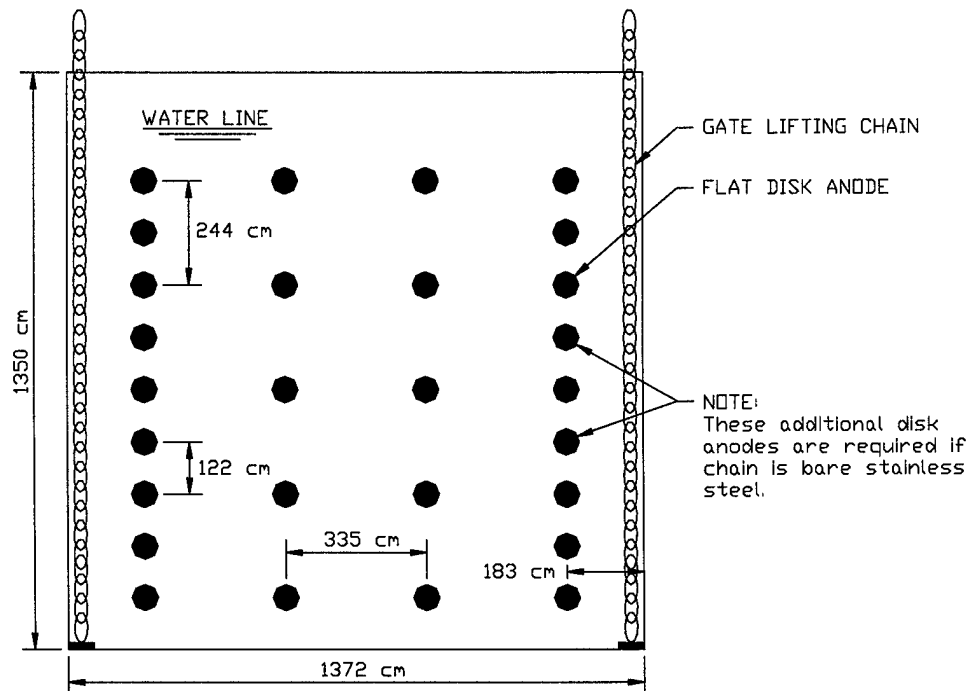


Figure B7. Tainter gate design at Cordell Hull showing flat disk anode placement

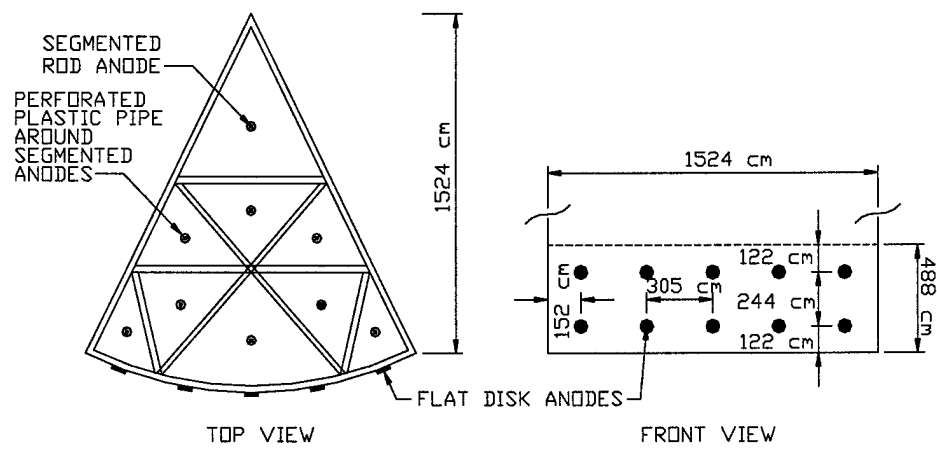


Figure B8. Sector gate design at Cape Canaveral showing flat disk anode placement